Winchester® Super X® 3 Autoloading Shotgun Owner's Manual

Important instructions for

Winchester® Super X® 3 Autoloading Shotgun

Winchester Rifles and Shotguns

Customer Service Department (United States)

BACO, Inc.

275 Winchester Avenue

Morgan, Utah 84050-9333

Phone: (800) 945-5237

If you have any questions or comments regarding your new firearm, please feel free to write or call us. Use the space below to record information about your new firearm.

Model _____

Serial Number _____

Purchased From _____

Date of Purchase _____

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NEU06101.5/06013

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GUN SAFETY WARNINGS

IT IS ESSENTIAL THAT THESE OPERATING INSTRUCTIONS BE THOROUGHLY STUDIED BEFORE USING THIS FIREARM TO ASSURE PROPER AND SAFE FIREARM HANDLING. FAILURE TO FOLLOW THESE INSTRUCTIONS OR FAILURE TO OBEY ANY SAFETY WARNING MAY RESULT IN INJURY TO YOURSELF OR OTHERS, OR CAUSE DAMAGE TO YOUR FIREARM.

As a firearm owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can be the difference between life and death. There is no excuse for careless or abusive handling of any firearm. At all times handle your shotgun and any other firearm with intense respect for its power and potential danger.

PLEASE READ AND UNDERSTAND ALL OF THE CAUTIONS, PROPER HANDLING PROCEDURES AND INSTRUCTIONS OUTLINED IN THIS OWNER'S MANUAL BEFORE USING YOUR NEW FIREARM.

1. Do not carry a loaded firearm with a live shell in the chamber while running, climbing a tree, crossing a fence or anywhere you might slip or fall, drop the firearm or otherwise bump or jar the firearm. A firearm that is dropped, bumped or jarred with a chambered shell might accidentally discharge even with the safety on, causing serious injury to you or someone else. When you are ready to shoot and a shell is chambered, keep the safety in the "on safe" position until shooting is imminent.
2. Do not rely on the safety to prevent accidental discharge. Many safeties merely block the trigger and prevent firing by pulling the trigger. The safety may not prevent an accidental discharge due to dropping, jarring or bumping a firearm.
3. Use only ammunition for which the firearm is chambered, as indicated on the barrel, to prevent excessive pressure and possible serious personal injury.
4. Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure. Reload only after proper instruction and in strict compliance with instructions and data contained in current reloading manuals.
5. Never point a firearm at anything you do not intend to shoot. Always keep it pointed in a safe direction in case of accidental discharge.
6. Always check to ensure that the barrel is free of obstructions before loading and using the firearm. If you experience light recoil or off sound, check the barrel for an obstruction.

7. Before firing, clean any grease or oil out of the barrel with a cleaning rod and patch. Grease or heavy accumulation of oil can cause excessive pressures and result in serious personal injury.
8. Keep barrel, chamber and action free of rust. Rust in the barrel and chamber can cause excessive pressures resulting in serious injury. A rusted, pitted or eroded barrel should be replaced.
9. Use hearing protection to prevent ear damage from repeated exposure to gunfire.
10. Always use proper shooting glasses to prevent eye injury from flying particles.
11. Never carry a loaded firearm in a motor vehicle or carry one into a dwelling. Always carefully unload the firearm before entering a motor vehicle, a dwelling or an area such as a camp. Always point your firearm in a safe direction while loading or unloading to prevent serious injury in case of an accidental discharge. Never load your firearm in a house or in a vehicle.
12. Never shoot at a hard, flat surface or at the surface of water to avoid a ricochet and possible serious personal injury to yourself or a bystander.
13. Store firearms in a clean, dry place out of reach of children and separated from stored ammunition.
14. Never alter any parts of your firearm. Any alterations or adjustments that may become necessary to the operating mechanism should be performed by a qualified gunsmith.
15. Hunting from elevated surfaces, such as tree stands, is dangerous. Doing so may increase the risk of handling any firearm. Always make certain that the stand being used is safe, sturdy and stable. Always make certain your firearm is unloaded when it is being taken up and down from the stand. Always make certain that your firearm is not dropped from the stand or dropped while it is being taken up or down from the stand.
16. Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

General Description

The Super X® 3 is a world-class shotgun with world-class origins. Every aspect of the design points toward unmatched reliability and superb handling. It is clear that this shotgun has the performance features demanded by serious hunters and shooters. A few things to take notice of are:

- The remarkably simple, self-adjusting Active Valve gas piston system.
- The alloy receiver balances weight between the hands with just enough barrel weight for a smooth swing.
- The acclaimed Invector-Plus™ choke system incorporates long choke tapers and a back-bored barrel for superior shot patterns.

As you learn about your new shotgun and begin shooting it, we're sure you'll agree its design sets new standards for reliability and handling.

Your new shotgun is one of several different versions and configurations offered. The basic operating procedures are the same for all models. Where there are differences, they are pointed out in this owner's manual for your convenience.

General Operation

This shotgun is an autoloading design that allows you to fire follow-up shots by merely pulling the trigger. When you fire a shell, the Active Valve gas system moves a shell from the magazine to the chamber where it is fired with a pull of the trigger. This can be repeated until the magazine is empty. A single shell can also be inserted into the chamber manually or moved from the loaded magazine by cycling the action with the operating handle.

With the magazine three-shot adapter (plug) removed from the magazine and using 2¾" loads, the shotgun is capable of shooting five shots in rapid succession, one shot with each pull of the trigger. The short stroke of the gas piston along with the snug, gas sealing fit of the gas piston rings and tight fit of the piston sleeve push rod limit the amount of combustion gases blown past the piston sleeve and into the receiver, keeping the inside of the receiver cleaner. This is an exceptionally advanced design that offers reliable function from the gas system and easy disassembly for maintenance and cleaning. However, in order to keep your new shotgun in top condition and operating at its peak performance, you must read, understand and follow all of the instructions in this owner's manual.

Prior to using live ammunition, familiarize yourself thoroughly with these operating instructions. Get accustomed to the feel of your new firearm. Know the forces required to operate the action. Learn how to pull the trigger, and above all, know the location and operation of the safety. Procedures for disassembly and operation of various components are outlined later in this owner's manual. Please read and study them thoroughly. In addition, always remember:

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. USE THE CORRECT AMMUNITION AS REFERENCED BY THE INSCRIPTION ON THE BARREL.

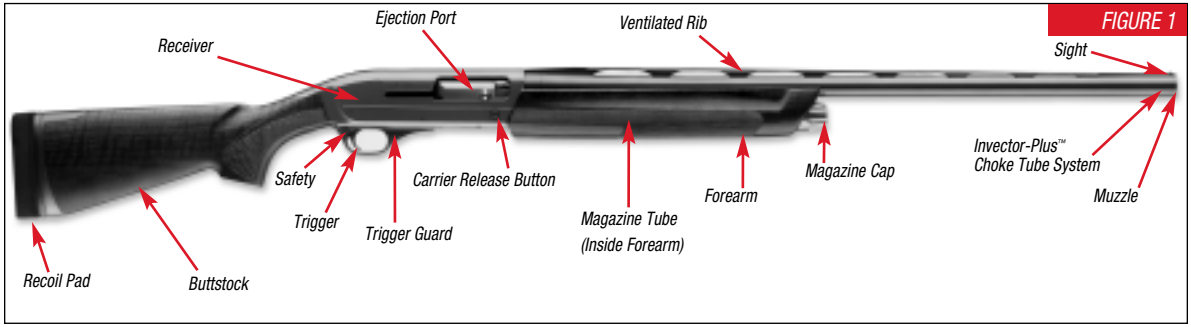


FIGURE 1

BEFORE LOADING YOUR FIREARM BE SURE ALL GREASE AND OIL HAVE BEEN REMOVED FROM THE BARREL AND CHAMBER, AND THERE ARE NO OBSTRUCTIONS.

TERMINOLOGY AND DESCRIPTIONS

Descriptions in this owner's manual generally refer to the firearm in the horizontal position; that is, in the normal firing position. For example, the muzzle is forward or front; the butt stock is rearward or rear; the trigger is downward or underneath; the sight is upward or on top. For general parts terminology refer to Figure 1.

The shotgun is also shown disassembled to the extent necessary in order to follow instructions contained in this book (Figure 20, page 27). Figure 3 (page 6) covers the general features and benefits of the shotgun's design. Throughout this owner's manual the term "action" refers to the mechanism of this shotgun which loads and secures the shell in the chamber.

SERIAL NUMBER

The serial number is located on the left side of the receiver, just above the trigger guard. Record the serial number at the front of this owner's manual for future reference.

INITIAL CLEANING AND OILING

Some metal parts of your new shotgun have been coated at the factory with a rust preventative compound. Before

using your shotgun, clean the anti-rust compound from the inside of the barrel, receiver, bolt mechanism and the action/chamber areas. A high quality, lightweight gun oil should be used to remove this compound and to give your new firearm its first lubrication. Clean the barrel using a cleaning rod and patch as explained under "Cleaning and Maintenance Suggestions" found on page 33 in this owner's manual.

If your new shotgun is to be stored for an extended period of time, it is permissible to leave the rust preventative compound in place and keep your shotgun in its box for maximum protection during long-term storage.

Before beginning assembly of your shotgun, you should first wipe the mechanism clean and apply a few drops of quality oil to the rails on which the bolt slides. These are found inside the receiver (Figure 2). Avoid applying too much oil.

FIGURE 2

Be sure you lightly oil the bolt rails inside the receiver at these points.

Only a light film is necessary. Excessive oil should be wiped off, especially in cold weather.

CLEANING PARTS WITH SPECIAL FINISHES —

Be especially careful when cleaning firearms with camouflage, Dura-Touch® Armor Coating and other special finishes. Always prevent these surfaces from coming in contact with cleaning solvents, barrel scrubbers and other strong chemicals. It is preferable to clean these surfaces with a light gun oil containing no solvents or with a damp cloth and mild dish soap (be sure to keep water out of the action). When cleaning your firearm's bore and action, protect the external finishes from any contact with chemicals used. Also, avoid any contact between external finishes and other strong chemicals like those found in DEET-containing insect repellents, sunscreens, etc. Damage to camouflage, Dura-Touch and other finishes caused by chemicals is irreversible and unrepairable.

AMMUNITION

There are two basic versions of this shotgun, those with a 3½" chamber and those with a 3" chamber. This information can be found inscribed on the barrel.

(Continued on page 8.)

SX3™

SHOTGUN FEATURES

The advanced aluminum alloy receiver offers the strength of steel and exceptional between-the-hands balance. Camo and Perma-Cote™ UT finishes are both durable and good looking, with minimal glare.

The entire bolt assembly removes easily for thorough cleaning. This is a firearm designed for extreme reliability under real-world, adverse hunting conditions.

Several stock materials are available. Choose from black or camouflage composite models with grip enhancing Dura-Touch® Armor Coating, or traditional walnut models.

The large safety button offers excellent convenience with both gloved and ungloved fingers. Plus, it is reversible for left-handed shooters.

The trigger assembly quickly removes with a durable two-pin system for easy maintenance and cleaning.

A deluxe next generation Pachmayr® Decelerator® recoil pad provides maximum comfort. The hard heel prevents snagging on clothing when shouldering.

FIGURE 3

Lightweight, machined ventilated rib.

.742" Back-Bored Technology creates the ideal bore diameter, providing improved pattern performance and shot velocity.

The advanced Active Valve gas system uses just the right amount of gas needed to cycle the action. The 3½" models shoot factory 12 gauge field loads from 2¾" to 3½" (1⅛ oz. to 2¼ oz.) loads. The 3" model shoots factory 12 gauge field loads from 2¾" to 3" (1 oz. field to 2 oz.) loads.

The longer Invector-Plus choke tubes have special tapers for optimum patterning, and they are specially designed for back-bored barrels. It allows you to change choke constrictions to meet the demands of the game being hunted or target presentation. Extra-full choke tubes are available for hunting turkey or other game requiring extremely tight patterns with lead shot loads.

- **3½" —** These models have a 3½" chamber designed to shoot factory 12 gauge loads including 2¾", 3" and 3½" (1⅛ oz. to 2¼ oz.) field loads. (They are NOT designed to shoot the lightest factory ⅞ oz. and 1 oz. loads.)
- **3" —** These models have a 3" chamber designed to shoot factory 12 gauge loads including 2¾" and 3" (1 oz. to 2 oz.) field loads. (They are NOT designed to shoot the lightest factory ⅞ oz. and 1 oz. target loads or any 3½" shells.)

Winchester ammunition is always an excellent choice for your new Winchester firearm, delivering the unmatched performance and dependability you want.

USE ONLY THE EXACT AMMUNITION/GAUGE AS LISTED ON THE LEFT SIDE OF THE BARREL. WINCHESTER FIREARMS CAN ASSUME NO RESPONSIBILITY FOR INCIDENTS WHICH OCCUR THROUGH THE USE OF CARTRIDGES OF NONSTANDARD DIMENSION OR THOSE THAT, WHEN SHOT, DEVELOP PRESSURES IN EXCESS OF INDUSTRY STANDARDS ESTABLISHED BY THE SPORTING ARMS AND AMMUNITION MANUFACTURERS' INSTITUTE (SAAMI). DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE.

Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure. Reload only after proper instruction and in strict compliance with instructions and data contained in current reloading manuals.

Operation of the Safety

This shotgun is designed with a cross-bolt-type safety. It is located just rearward of the trigger on the trigger guard, and is convenient for gloved or ungloved fingers. It is essential that you become very familiar with the feel, look and operation of the safety on this shotgun before attempting to load and shoot.

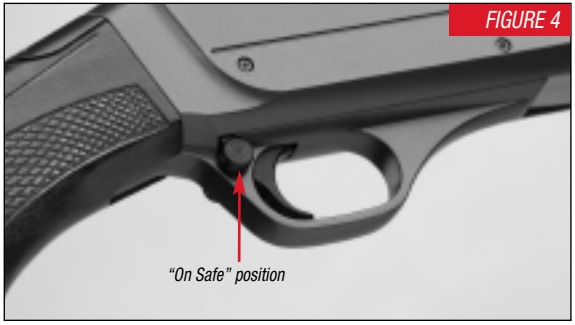
The cross-bolt safety prevents the trigger from being pulled when in the "on safe" position. In the "off safe" position, if your firearm is loaded with a shell in the chamber, the chambered shell can be fired by simply pulling the trigger.

The safety on this shotgun is reversible for right- or left-handed operation. It comes from the factory in the right-handed position. Verify the installation of your firearm's safety. Instructions in this owner's manual are for the safety installed in the right-handed position.

- **"On Safe" —** The safety button is pushed fully to the right. The red band on the left side is not showing (Figure 4). Always maintain the safety in the "on safe" position (fully on) when a cartridge is in the chamber and until shooting is imminent.
- **"Off Safe" —** The safety button is pushed fully to the left. A large red band is exposed on the button as it protrudes on the left side of the trigger guard. The red band is an added aid to safe gun handling (Figure 5).

CAUTION: THE RED WARNING BAND ON THE SAFETY BUTTON IS FOR CONVENIENCE ONLY. DO NOT DEPEND ON THE RED COLOR ALONE TO INDICATE YOUR FIREARM'S SAFETY STATUS, AS TIME, EXPOSURE TO THE ELEMENTS, AND THE ABRASIVE ACTION OF CLEANING AGENTS CAN ERASE IT.

Never rely totally on your firearm's safety button. It is merely an aid to safe gun handling. Like any mechanical device the safety can possibly fail; it can be jarred or inadvertently manipulated into an unsafe condition. Always keep your shotgun pointed in a safe direction. At all times in the field keep the safety in the "on safe" position and the barrel pointed in a safe direction. It is a good idea never to load your shotgun until you are in the field and shooting is imminent or until you are at your station and it is your turn to shoot when you are shooting at a range. For extra safety, and as a courtesy to others, fully unload and place the action in the open position at all times other than when shooting is immediately imminent.



IT IS ESSENTIAL THAT YOU BECOME VERY FAMILIAR WITH THE FEEL, LOOK AND OPERATION OF THE SAFETY ON THIS SHOTGUN BEFORE ATTEMPTING TO LOAD AND SHOOT IT.

IMPORTANT: THE SAFETY ON THIS SHOTGUN CAN BE REVERSED FROM RIGHT- TO LEFT-HANDED BY A QUALIFIED GUNSMITH. WHEN REVERSED TO LEFT-HANDED, THE SAFETY BUTTON'S RED WARNING BAND WILL SHOW ON THE RIGHT SIDE OF THE TRIGGER GUARD WHEN THE SAFETY IS IN THE "OFF SAFE" POSITION.

Initial Assembly and Takedown

Assembly —

Remove the barrel assembly and receiver/stock section from the carton. The shotgun usually comes from the factory with the barrel removed and the forearm still attached to the magazine tube. Wipe them clean and lightly oil component parts as explained under "Initial Cleaning and Oiling" on page 4. It is important to carefully follow the assembly instructions below — especially steps 1, 2 and 3 — to assure the proper assembly of your shotgun.

ALWAYS PLACE THE SAFETY IN THE "ON SAFE" POSITION BEFORE BEGINNING ASSEMBLY PROCEDURES. VISUALLY INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO BE ABSOLUTELY CERTAIN THE SHOTGUN IS COMPLETELY UNLOADED. POINT THE BARREL IN A SAFE DIRECTION.

1. Lock the bolt rearward by pulling the operating handle fully to the rear. If it will not pull rearward it usually indicates that the bolt slide link has fallen out of the end of the socket on the return spring plunger while your firearm was being shipped. This is not a problem. Refer to the section titled "Bolt Maintenance" on page 30 in this owner's manual for special instructions on how to perform this alignment procedure.

2. Carefully remove the forearm from the magazine tube by unscrewing the magazine cap and sliding the forearm forward off the magazine tube. ***DO NOT SQUEEZE HARD ON THE OPEN REAR END OF WOOD FOREARMS. TOO MUCH PRESSURE COULD CAUSE THE WOOD TO SPLIT.***

   The magazine spring is held in place by a friction-type magazine spring retainer. ***ALWAYS KEEP THE MAGAZINE POINTED AWAY FROM YOU AND OTHERS WHEN REMOVING THE MAGAZINE CAP.***

3. Leave the components of the gas system (the piston sleeve, piston sleeve spring and gas piston) in place on the magazine tube. They do not need to be removed, except for cleaning. In the event that components of the gas system have been removed, it is easy to reinstall them as explained below.

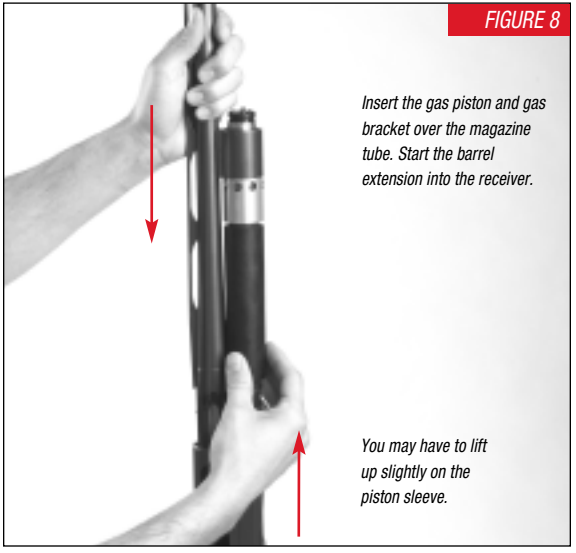
FIGURE 7

Position the gas piston in the gas bracket on the bottom of the barrel.

4. If the gas piston, piston sleeve and piston sleeve spring have been removed, first slide the piston sleeve spring over the magazine tube. Then slide the piston sleeve onto the magazine tube, piston sleeve push rod end first. Check the piston sleeve push rod to make sure it is aligned with the slot on the left side of the receiver (Figure 6), as viewed from the normal shooting position.

5. Slide the gas piston into the rear of the gas bracket on the barrel, smaller end first (Figure 7).

FIGURE 8



Insert the gas piston and gas bracket over the magazine tube. Start the barrel extension into the receiver.

You may have to lift up slightly on the piston sleeve.

6. Hold the firearm in the vertical position. Slide the gas bracket and gas piston over the magazine tube (Figure 8). The barrel extension should slip solidly down into the receiver. Make sure the piston sleeve push rod on the piston sleeve moves freely in its slot in the left side of the receiver. On a new firearm with very tight tolerances, it may be necessary to lift up slightly on the piston sleeve to allow the barrel extension to drop into the receiver. After you do this, always check piston sleeve push rod alignment as explained previously.
7. Replace the forearm by sliding it onto the magazine tube and over the gas bracket so it seats securely. Install the magazine cap. Make sure the magazine cap is fully tightened down. Open and close the action several times and then retighten the magazine cap. This will help ensure a proper seal.

TAKEDOWN —

ALWAYS PLACE THE SAFETY IN THE "ON SAFE" POSITION BEFORE BEGINNING DISASSEMBLY PROCEDURES. VISUALLY INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO BE ABSOLUTELY CERTAIN THE SHOTGUN IS COMPLETELY UNLOADED. POINT THE BARREL IN A SAFE DIRECTION.

Disassembly for storage is essentially the reverse of the assembly procedures. The action should be left open if disassembly of the rest of the firearm will not be performed. If you intend to fully disassemble your firearm, you may start with the action closed.

1. Unscrew the magazine cap and remove it. Because the magazine spring is held in place by a friction-type magazine spring retainer, always be careful which direction the end of the magazine is pointed.

ALWAYS KEEP THE MAGAZINE POINTED AWAY FROM YOU AND OTHERS WHEN REMOVING THE MAGAZINE CAP.

2. Remove the forearm by sliding it forward off the magazine tube.
3. If you are disassembling your shotgun for cleaning remove the barrel, gas piston, piston sleeve and piston sleeve spring by sliding them forward off the magazine tube. See "Cleaning and Maintenance Suggestions" on page 33 in this owner's manual for cleaning procedures. If you are disassembling for storage, lock the action open. Leave the gas piston, piston sleeve and piston sleeve spring on the magazine tube as explained previously. Reinstall them if they have been removed. Install the forearm over the magazine tube and screw on the magazine cap. You will then have two compact units: (1) the barrel, and (2) the action with forearm and stock.

CAUTION: AFTER THE BARREL HAS BEEN REMOVED FROM YOUR FIREARM, AND YOU INTEND TO STORE YOUR FIREARM, LEAVE THE BOLT IN THE OPEN POSITION. DO NOT PRESS THE CARRIER RELEASE BUTTON. IF THE BOLT IS RELEASED FORWARD WITH THE BARREL REMOVED, THE OPERATING HANDLE WILL HIT THE FRONT OF THE EJECTION PORT AND CAUSE DAMAGE TO BOTH THE RECEIVER AND THE OPERATING HANDLE.

Magazine Capacity

It is extremely important that you know the magazine capacity of your shotgun. It is listed on the hang tag supplied with your shotgun. Under appropriate circumstances — at a range or other suitable shooting location — load your magazine to full capacity and make note of the number of shells. Remember, "total capacity" includes an additional shell which can be loaded manually in the chamber in addition to a full magazine. Total capacity is generally (magazine, plus chamber) as follows:

- **3½" Models —**
  3" and 3½" magnum shells: three in magazine, one in chamber. 2¾" shells: four in magazine, one in chamber.
- **3" Models —**
  3" magnum loads: three in magazine, one in chamber. 2¾" shells: four in magazine, one in chamber.
- **With Magazine Three-Shot Adapter (Plug) Installed —**
  Two shells in magazine, one in chamber.

IMPORTANT: Because 3" and 3½" shotguns can handle mixed shells of different lengths, total capacity may be affected.

Loading

There are two ways to load the chamber of your shotgun. Use the correct ammunition referenced by the inscription on the barrel. Before loading your shotgun, make sure of the following:

- Be sure all grease and oil have been removed from the barrel and chamber and there are no obstructions.
- Your shotgun is pointed in a safe direction.
- The safety is in the "on safe" position.
- You are in an appropriate location for shooting.
- Shooting is imminent.

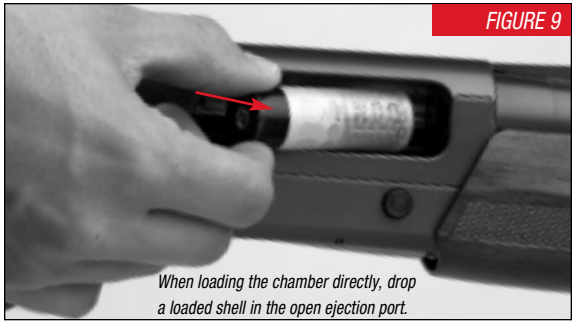


FIGURE 9

When loading the chamber directly, drop a loaded shell in the open ejection port.

FIRING A SINGLE SHOT —

1. Place the safety in the "on safe" position.
2. Open the action by pulling back fully on the operating handle. The bolt will lock in the rearward position. Always verify that the magazine and chamber contain no shells when the action is opened.
3. A shell can now be placed directly into the ejection port (Figure 9).
4. Press the carrier release button located just below the ejection port. This will automatically move the shell placed in the ejection port into the chamber. Keep your fingers clear of the ejection port when closing the action with the carrier release button.

IMPORTANT: THE FIREARM IS NOW READY TO FIRE BY MOVING THE SAFETY TO THE "OFF SAFE" POSITION AND PULLING THE TRIGGER. DO NOT CARRY A FIREARM WITH A SHELL IN THE CHAMBER TO AVOID ACCIDENTAL DISCHARGE. IN ALL CASES, WHEN LOADING AND WHEN FIRING IS NO LONGER IMMINENT, MAKE SURE THE SAFETY IS IN THE "ON SAFE" POSITION.

After firing with an empty magazine, the bolt will lock rearward, ready for inserting the next shell into the open ejection port.

LOADING THE MAGAZINE —

1. Place the safety in the "on safe" position and close the action by pressing the carrier release button.
2. With your thumb on the base of the shell, push the shell through the loading port at the bottom of the receiver

FIGURE 10

Push the shell all the way into the magazine. Make sure you push the rim of the shell past the shell stop.

up into the magazine until the shell is held in the magazine by the shell stop (Figure 10). Make sure the rim of the shell engages the cartridge stop and is held fully inside the magazine tube. It will make an audible click when fully inserted.

3. Repeat the procedure until the magazine is fully loaded.
4. If firing is imminent, a shell can be moved from the magazine to the chamber by pulling back fully on the operating handle and releasing it forward. A shell will be fed from the magazine to the chamber as the bolt closes. Another shell can then be inserted into the magazine, reloading it to full capacity.

IMPORTANT: THE FIREARM IS NOW READY TO FIRE BY MOVING THE SAFETY TO THE "OFF SAFE" POSITION AND PULLING THE TRIGGER. DO NOT CARRY A FIREARM WITH A SHELL IN THE CHAMBER TO AVOID ACCIDENTAL DISCHARGE. IN ALL CASES, WHEN LOADING AND WHEN FIRING IS NO LONGER IMMINENT, MAKE SURE THE SAFETY IS IN THE "ON SAFE" POSITION.

Firing

The autoloading operation of this shotgun is the obvious primary benefit to the shooter. For training or target situations your firearm can be fired "single shot" by loading one shell at a time through the open ejection port. More commonly, you will take advantage of the autoloading feature by loading the entire magazine first and then firing repeated shots, if necessary. Both methods are described earlier under "Loading Procedures" on page 13.

1. When ready to shoot, and with a shell loaded in the chamber, the safety "on safe", and your finger off the trigger, push the safety to the "off safe" position (with the red warning band fully visible). Your shotgun is now ready to fire with a pull of the trigger.

   CAUTION: YOUR SHOTGUN IS NOW READY TO FIRE. REMEMBER, THE RECOIL FROM A SHOTGUN, ESPECIALLY WITH MAGNUM LOADS, WILL BE SOMEWHAT HEAVIER THAN MOST OTHER FIREARMS. FIRMLY SHOULDER YOUR SHOTGUN, TAKE AIM, AND, WHEN ON TARGET, PULL THE TRIGGER.

2. As the shell in the chamber is fired, gases from the propellant are bled off from the barrel at the gas bracket. This forces the gas piston rearward which in turn moves the bolt assembly rearward, ejecting the fired shell.
3. As the bolt returns forward under spring force, a shell from the magazine is automatically transferred from the magazine to the chamber and the bolt locks forward. Your firearm will now fire again with the pull of the trigger. Immediately put the safety in the "on safe" position (with the red warning ring hidden) until you are ready to fire again.

4. You may fire until the magazine is empty. The bolt will lock open after the last shot has been fed from the magazine, fired and ejected. When the bolt locks open this usually indicates that both the magazine and chamber are empty, and that your shotgun magazine needs to be reloaded. It is important to treat your firearm as though it is loaded, even if the action has locked open. At this point either reload the magazine (if shooting is going to continue) or fully unload your shotgun (if shooting is completed). Either way, place the safety in the "on safe" position.

WHEN FIRING IS COMPLETED OR WHEN SHOOTING IS NO LONGER IMMINENT, IMMEDIATELY RETURN THE SAFETY TO THE "ON SAFE" POSITION. UNDER NO CIRCUMSTANCES SHOULD YOU MOVE ON OR CONTINUE TO HUNT WITH THE SAFETY IN THE "OFF SAFE" POSITION.

UNLOADING

WHEN UNLOADING YOUR SHOTGUN, POINT THE MUZZLE IN A SAFE DIRECTION. PLACE THE SAFETY IN THE "ON SAFE" POSITION AND MAKE SURE THE ACTION IS CLOSED.

1. Grasp the operating handle and cycle the action until all shells are transferred from the magazine to the chamber and then ejected. You should always take care to avoid damaging shells. Do not let them fall on hard ground.
2. When the last shell in the magazine has been cycled from the magazine, through the chamber and out the ejection port, the action should lock rearward

IMPORTANT: AFTER UNLOADING ALWAYS VISUALLY INSPECT THE CHAMBER TO BE CERTAIN THAT YOUR SHOTGUN IS COMPLETELY UNLOADED.

IN THE CASE OF A MISFIRE

Only rarely will modern factory ammunition experience a misfire. If this ever happens to you when shooting your shotgun, please follow these instructions carefully.

CAUTION: IN CASE OF MISFIRE, KEEP THE BARREL POINTED IN A SAFE DIRECTION, CAREFULLY OPEN THE ACTION WHILE AVOIDING DIRECT EXPOSURE TO THE BREECH BY YOURSELF AND OTHERS. REMOVE THE SHELL FROM THE CHAMBER. PLACE THE SAFETY IN THE "ON SAFE" POSITION AND COMPLETELY UNLOAD YOUR SHOTGUN, REMOVING ALL SHELLS FROM THE MAGAZINE.

Carefully inspect the ejected shell. If the primer is indented, the shell should be disposed of in a manner that would prevent accidental injury to you, others, or the

environment. If there is no indentation, your firearm has malfunctioned and should be serviced by a qualified gunsmith, or by a Winchester Firearms Authorized Repair Center (ARC) (page 37).

INVECTOR-PLUS™ CHOKE TUBE SYSTEM

This shotgun is fitted with the Invector-Plus choke tube system, one of the most popular systems on the market. This means:

- It has a back-bored barrel.
- It is threaded to accept Invector-Plus choke tubes only.

The Invector-Plus system allows you to configure your shotgun for the shot pattern and/or choke constriction your hunting or target shooting situation demands. The back-bored barrel and highly engineered choke tapers produce the best possible patterns for target and field situations. It is extremely easy to switch choke constrictions to match your shooting conditions. Invector-Plus tubes are fully compatible with steel and lead shot. Most Invector-Plus choke tubes fit flush with the muzzle when installed. A special choke tube wrench is provided to remove and tighten these tubes. Invector-Plus choke tubes are NOT interchangeable with any other choke tubes on the market including chokes listed as "Standard Invector™" or "WinChoke®" choke tubes.

USE ONLY CHOKE TUBES MARKED "INVECTOR-PLUS" IN YOUR SHOTGUN. USE ONLY THE APPROPRIATE GAUGE OF INVECTOR-PLUS CHOKE TUBES AS MARKED ON YOUR SHOTGUN.

Failure to follow these warnings may damage your firearm and cause injury to yourself and others. A special Invector-Plus choke tube wrench is provided to remove and tighten Invector-Plus choke tubes.

DO NOT FIRE THIS SHOTGUN WITHOUT HAVING AN INVECTOR-PLUS CHOKE TUBE INSTALLED. PERMANENT DAMAGE MAY RESULT TO THE BARREL THREADS.

CAUTION: WHENEVER HANDLING ANY SHOTGUN FOR THE PURPOSE OF REMOVING OR INSTALLING A CHOKING DEVICE, MAKE ABSOLUTELY CERTAIN THE FIREARM IS COMPLETELY UNLOADED, AND THE BOLT OR BREECH IS OPEN! NEVER ATTEMPT TO REMOVE OR INSTALL A SHOTGUN CHOKING DEVICE ON A LOADED FIREARM!

CHOKE TUBE REMOVAL —

1. ***COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***
2. Open the action, locking it rearward, and place the safety in the "on safe" position.

3. Use the Invector-Plus wrench to loosen the choke tube, turning it counterclockwise. Unscrew the choke tube the rest of the way out of the barrel with your fingers.

CHOKE TUBE INSTALLATION —

1. ***COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***
2. Open the action, locking it rearward, and place the safety in the "on safe" position.
3. Before installing a tube, check the internal choke tube threads in the muzzle, as well as the threads on the Invector-Plus choke tube to be sure they are clean. Lightly oil the choke tube's threads with a high quality lightweight oil.
4. Using your fingers, screw the appropriate tube into the muzzle end of the barrel, tapered end first, notched end outward. When it becomes finger tight, use the Invector-Plus choke tube wrench to firmly seat the tube.

THE INVECTOR-PLUS CHOKE TUBE SHOULD BE PERIODICALLY CHECKED TO ASSURE THAT IT IS TIGHT AND FIRMLY SEATED. BEFORE CHECKING, FOLLOW THE SAFETY GUIDELINES OUTLINED ABOVE.

SELECTING THE CORRECT INVECTOR-PLUS CHOKE TUBE —

The Invector-Plus choke system is fully compatible with factory lead or steel shot loads. The conversion chart includes both lead and steel shot information. Lead and steel shot perform differently in tubes with the same choke constriction. For this reason, both lead and steel designations are provided. Larger steel shot diameters also result in different patterns than smaller steel shot sizes. Each designation is inscribed on each choke tube. To help you choose the correct choke tube for each target shooting and hunting situation, all Invector-Plus choke tubes are inscribed on the side with abbreviations for the patterns they produce with both lead and steel shot. Each tube also features identification notches located on the top rim of each tube (Figure 11). These notches are a code to allow you to determine the choke designation while the tube is installed. Rim notches refer specifically to lead shot. Use the chart on page 19 to cross-reference from lead to steel, and determine the appropriate tubes for your ammunition and hunting/shooting situation.

It is helpful to note that bismuth shot patterns similarly to lead shot and tungsten shot patterns more like steel shot.

FIGURE 11

1 Notch:
Full

2 Notches:
Improved Modified

3 Notches:
Modified

4 Notches:
Improved Cylinder

5 Notches:
Skeet

No Notches:
Cylinder

Tube Notch Codes (Lead shot designations). Small notches indicate the choke tube code. Large notches are for the choke tube wrench.

CHOKE TUBE RIM NOTCH CODES AND PATTERNS

Rim Notches	Pattern With Lead Shot	Pattern With Steel Shot
Knurled**	X-Full Turkey	**
I	Full	*
II	Imp. Modified	Full[1]
III	Modified	Full[1]
IIII	Imp. Cylinder	Modified
IIIII	Skeet	Imp. Cylinder
No Notches	Cylinder	Cylinder

* Not for use with steel shot. Using an over-tight choke constriction with steel shot will result in an ineffective "blown" pattern.

** Extra Full Turkey with knurled rim. Do not use with steel shot.

[1] When more than one choke designation is listed for a given steel shot pattern, use the more open choke listed for high velocity, larger shot size steel loads.

MAGAZINE THREE-SHOT ADAPTER (PLUG)

The shotgun is delivered with the magazine three-shot adapter (plug) installed in the magazine, limiting magazine capacity to two shells in compliance with federal migratory bird regulations. If you do not wish to be limited to three shots — when it is not required by law — you can remove the plug. Removal and installation of the plug can be performed with the barrel in place or with the barrel removed from the action.

IMPORTANT: Use only the plug supplied with your shotgun or a replacement part made specifically for your shotgun by Winchester Rifles and Shotguns. This is a special plug design that maximizes the performance of your firearm with any load. The use of any other plug may affect performance of the magazine system.

FIGURE 13
Slowly remove the magazine spring retainer. Keep it under control with your hand as it is under spring pressure.

WHEN REMOVING OR INSTALLING THE MAGAZINE THREE-SHOT ADAPTER (PLUG), MAKE CERTAIN THE SAFETY IS IN THE "ON SAFE" POSITION. BE CERTAIN THERE ARE NO SHELLS IN THE MAGAZINE OR CHAMBER AND KEEP THE BARREL POINTED IN A SAFE DIRECTION AT ALL TIMES. REMEMBER, THE PLUG IS UNDER SPRING PRESSURE SO CARE MUST BE TAKEN FOR SAFE REMOVAL. ALWAYS POINT THE END OF THE MAGAZINE AWAY FROM YOUR FACE AND IN A SAFE DIRECTION. NEVER LOOK DIRECTLY DOWN INTO THE CAP END OF THE OPEN MAGAZINE. ALWAYS WEAR EYE PROTECTION WHEN REMOVING AND REINSTALLING THE MAGAZINE PLUG.

REMOVAL —

1. First, make certain the firearm is completely unloaded and the safety is in the "on safe" position.
2. Unscrew the magazine cap and remove it. Remember, always point the end of the magazine away from your face and in a safe direction.
3. Remove the forearm by sliding it forward over the gas bracket. It is also acceptable to remove the barrel as explained previously under "Takedown" on page 12.
4. The magazine plug lays underneath the magazine spring retainer locked in the forward end of the magazine tube. To remove the magazine spring retainer, depress the magazine spring retainer tab — located in the

window on the magazine tube — with a screwdriver while keeping your free hand on the magazine spring retainer (Figure 12). Slowly remove the magazine spring retainer as it is under pressure of the magazine spring (Figure 13).

5. As the spring pushes the retainer out of the tube the plug will come with it. Remove the retainer, the plug and the magazine spring from the magazine tube.
6. Remove the plug from between the retainer and the magazine spring (Figure 14).

INSTALLATION —

1. Depress the magazine spring back into the magazine tube and replace the magazine spring retainer over the top of the spring.
2. Align the magazine retainer tab with the rectangular slot in the magazine tube. Push the magazine spring retainer down into the magazine. Make sure the magazine spring retainer tab is locked in place in its retaining slot in the magazine.
3. Reinstall the barrel (if it was removed), the forearm and then the magazine cap as explained under "Initial Assembly/Takedown" on page 10.

In the future, should you wish to limit your firearm to three shots again, unscrew the magazine cap, remove the forearm and remove the magazine spring retainer as explained previously. Hold the spring down inside the magazine tube and insert the tapered end of the plug inside the spring. Lightly press the front end of the plug to force the magazine spring into the magazine until the base of the plug is level with the end of the magazine tube. Replace the magazine spring retainer, forearm and magazine cap. Make sure the magazine follower remains in place inside the rear of the magazine tube.

STOCK ADJUSTMENT

The stock of the shotgun can be adjusted for length of pull by adding or removing spacers to the rear of the stock. This feature applies to both wood and composite stock models. Each spacer extends length of pull ¼" and a maximum of three spacers can be added with the screws

FIGURE 15

Locate the two slits in the recoil pad and loosen the screws that hold the recoil pad in place.

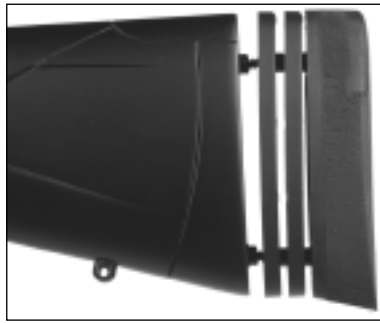


FIGURE 16

The stock spacers fit between the recoil pad and buttstock. With the included screws,up to three spacers can be used to increase length of pull.

provided to extend length of pull ¾". With longer screws (not provided), more than three spacers can be added to further extend length of pull.

Composite stocked models come from the factory with two spacers in the box. Wood stocked shotguns come with a ¼" thick spacer installed. Additional spacers can be ordered through your local Winchester Rifles and Shotguns dealer or by calling our Customer Service Department at (800) 322-4626.

Length of pull can be further shortened by having a gunsmith trim the stock and refit the recoil pad. Composite stock guns can be trimmed up to ½".

Shotguns with a composite stock also feature a shim adjustment system that allows fine tuning of drop at comb, heel and cast. Six shims are included.

To Adjust Length of Pull —

1. ***COMPLETELY UNLOAD YOUR SUPER X3 SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***
2. Use a #2 cross tip or Phillips screwdriver to remove the recoil pad at the end of the buttstock (Figure 15). Place a small amount of petroleum jelly on the screw access slits on the top and bottom of the rear of the buttstock to prevent damaging the recoil pad. Insert the screwdriver into each of the two access holes. Make certain the tip of the screwdriver engages the head of the screw. Turn the screw counterclockwise until the screw is completely loose from the stock. When both screws are free, remove the recoil pad.

3. Add or subtract spacers to fit your firearm to your specifications (Figure 16). After making an adjustment hold the shotgun to your shoulder to determine if the new length feels comfortable. Remember to always keep the muzzle pointed in a safe direction, with the safety in the "on safe" position and make certain the shotgun is completely unloaded.
4. When you are satisfied with the length of pull, start the screws through the pad and spacer(s) into the holes in the stock.
5. Attach the recoil pad to the stock using the screwdriver. Turn the screws clockwise to tighten. Do not overtighten the screws.

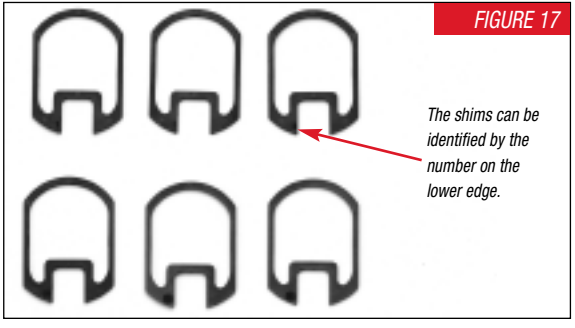


FIGURE 17

ADJUSTING CAST AND DROP AT COMB —

Six shims have been included with your composite stocked shotgun (Figure 17). The shims fit between the buttstock and receiver, allowing customized adjustments to the comb and heel. Each shim is labeled/stamped for a specific amount of adjustment. The neutral shim, No. 2, is already installed on your shotgun.

Drop at comb is defined as the place on the comb that your cheek rests when taking aim. If drop at comb is correct,your eye falls in line with the sight bead. Shims marked 1, 2 and 3 do not give any cast on or off. The stock remains straight. They only adjust drop at comb.

These shims with their respective stamps are further clarified here:

Shim 1 raises the comb approximately 1/16", and the heel approximately 1/8".

Shim 2 is neutral. This shim is already installed on your shotgun.

Shim 3 lowers the comb approximately 1/16", and the heel approximately 1/8".

Cast is the offset of the buttstock from the longitudinal center line of the firearm. Some right-handed shooters like the stock to angle away (cast off) from their face, making their line of sight more directly in line with the rib. Angling the stock to the left for left-handed

shooters is “cast on.” Shims marked 1R1L, 2R2L, and 3R3L, will all adjust drop at comb the same amount as shims 1, 2 and 3, and will also adjust the cast right or left approximately ⅛". You will notice that the two opposing edges of these spacers are different in thickness. These shims with their respective stamps are further clarified here:

Shim 1R1L adjusts the comb in the increment given above, (shim 1) and will adjust the cast on or cast off approximately ⅛”. For right-handed shooters, install this shim between the receiver and the stock with the R facing the end of the buttstock, so its thicker side is on the left side. This casts the stock slightly to the right, away from the face of a right handed shooter. If you turn the shim around so the L is facing the end of the buttstock, and it will cast the stock to the left.

Shim 2R2L adds the same amount of cast to the stock as shim 1RL and the same amount of drop to the comb as shim No. 2.

Shim 3R3L adds the same amount of cast to the stock as 2RL and 3RL, and lowers the comb approximately 1⁄16" and the heel approximately ⅛".

To Install a Shim —

1. ***COMPLETELY UNLOAD YOUR SUPER X3 SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***
2. Use a #2 cross tip or Phillips screwdriver to remove the recoil pad at the end of the buttstock (Figure 15). Place a small amount of petroleum jelly on the screw access

FIGURE 18

Use a socket to remove the nut that holds the buttstock in place.

FIGURE 19

Fit the shims to the buttstock.

slits on the top and bottom of the rear of the buttstock to prevent damaging the recoil pad. Insert the screwdriver into each of the two access holes. Make certain the tip of the screwdriver engages the head of the screw. Turn the screw counterclockwise until the screw is completely loose from the stock. When both screws are free, remove the recoil pad.

3. Using a ½" (Composite models) socket wrench, remove the stock bolt nut and stock bolt washer. (Figure 18).
4. Completely remove the buttstock from the receiver, along with the existing shim, and install the shim you have selected. Make certain you have the proper shim installed and in the proper position before reattaching the buttstock and recoil pad (Figure 19).
5. When you are satisfied with the fit, reattach the buttstock to the receiver with the washer and the nut.
6. Snug the nut down with the socket wrench, do not overtighten.
7. Attach the recoil pad with care, so as not to scratch or mar the finish of the stock.

Use of Extra Barrels

The versatility of your new shotgun can be extended with an extra barrel. All shotgun barrels are interchangeable within a given gauge and chamber length. No special fitting is required.

Some important restrictions must be observed:

- Never use a barrel with a 3½" chamber on a shotgun designed for barrels with a 3" chamber.
- Never use a barrel with a 3" chamber on a shotgun designed for barrels with a 3½" chamber.
- Never use a rifled barrel on a shotgun that was designed for non-rifled barrels.
- Never use any other barrel from any other manufacturer on your shotgun. Some other brands may seem similar, but the barrels are not interchangeable.
- Never use any barrel from other Winchester shotguns, including those for the Super X® Model 1 or Super X® 2.

FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN INJURY TO YOURSELF OR OTHERS.

Mounting a Scope

Some models are designed to accept a scope or other optical sight; usually these are turkey and deer models. The receiver tops of some of these models are drilled and tapped for scope bases, while other models are equipped with a cantilever scope base. If your shotgun has a cantilever mount, follow the mounting instructions supplied with your scope rings and/or scope. If your

shotgun's receiver is drilled and tapped for scope mounts, four holes (in line, in pairs on top of the receiver) will be visible. They are fitted with filler screws. If your shotgun is drilled and tapped you must adhere to the following:

WARNING: YOUR SHOTGUN IS DRILLED AND TAPPED FOR THE MOUNTING OF BASES AND RINGS TO ACCOMMODATE AN APPROPRIATE SCOPE OR SIGHT. ALWAYS USE THE CORRECT BASES FOR THIS SHOTGUN WITH THE APPROPRIATE LENGTH SCREWS WHICH ARE AT LEAST 11/32" IN LENGTH.

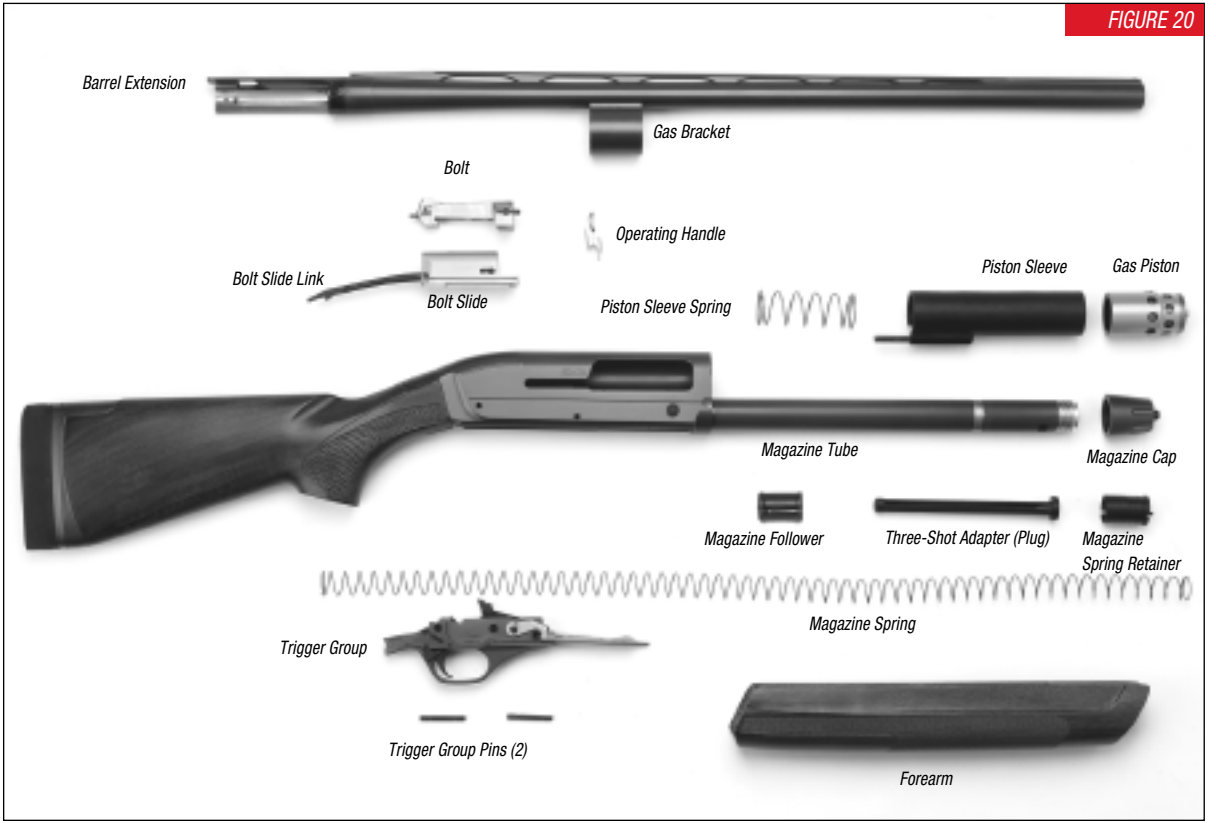
To mount scope bases on your shotgun, perform the following steps:

1. ***COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.*** Leave the action open. Make sure you place your shotgun on a table or other safe/secure location. Protect the finish with rags or other padding.
2. You should have a compatible one- or two-piece style base and four screws of at least 11/32" in length.
3. Clean all oil, grease or dirt from the receiver top and from the scope base parts.
4. Position your shotgun in the upright position with the top of the receiver upward.
5. Remove all four filler screws from the top of the receiver using a very small, thin-bladed gunsmithing-type screwdriver.
6. Pre-position the bases on the receiver top to determine the best orientation of the bases. Most bases have transverse grooves cut into them that are offset from the middle. These are the grooves that the crossbolts in your scope rings will pass through. The grooves are offset to allow you to position the bases to fit the design/length of your scope and the placement of the scope front to rear for proper eye relief. Place both grooves to the rear, both to the front, or one in each direction, depending on the desired position of your scope.
7. Once you know which configuration you will use, insert the screws through the bases and screw them into the receiver top using the correct wrench or screwdriver (usually a 3/32" hex wrench).

YOU MUST USE SCREWS WHICH ARE AT LEAST 11/32" IN LENGTH TO ENSURE PROPER THREAD ENGAGEMENT. ONCE THE BASES ARE INSTALLED, CHECK INSIDE THE RECEIVER TO VERIFY THAT THE BASE MOUNTING SCREWS ARE NOT TOO LONG AND INTERFERING WITH THE OPERATION OF THE BOLT.

Many gunsmiths find it helpful to use a drop of serviceable thread locking compound to assure the screws stay tight. Make sure the thread locking compound does not get into the action.

FIGURE 20


Barrel Extension
Gas Bracket
Bolt
Operating Handle
Bolt Slide Link
Bolt Slide
Piston Sleeve Spring
Piston Sleeve
Gas Piston
Magazine Tube
Magazine Cap
Magazine Follower
Three-Shot Adapter (Plug)
Magazine Spring Retainer
Magazine Spring
Trigger Group
Trigger Group Pins (2)
Forearm

BE CAREFUL TO ASSURE THAT THE THREADS OF EACH SCREW ENGAGE PROPERLY IN THE THREADS IN THE RECEIVER TO PREVENT STRIPPING THE THREADS IN THE ALLOY RECEIVER.

8. Tighten the screws snugly, but do not over tighten.
9. Mount your scope rings and scope as outlined in the instructions supplied with your scope rings and/or scope. Always make sure you have the proper eye relief. Always make sure that the saddle crossbolts and the cap bolts are fully tightened before using your shotgun.

Trigger Group Maintenance

One of the advantages of your shotgun is the ability to easily disassemble it for cleaning (Figure 20). Under very harsh weather conditions and in dirty environments just knowing that parts are clean and lightly oiled can add an extra measure of confidence to your shooting experience.

Make sure you have a clean place to work and a good place to put the components as they are disassembled.

WEAR EYE PROTECTION AT ALL TIMES. NEVER DISASSEMBLE BEYOND WHAT IS EXPLAINED AND SHOWN IN THIS OWNER'S MANUAL.

Disassembling the action can be done in the field, but remember, there are small parts involved, some of which are under spring tension.

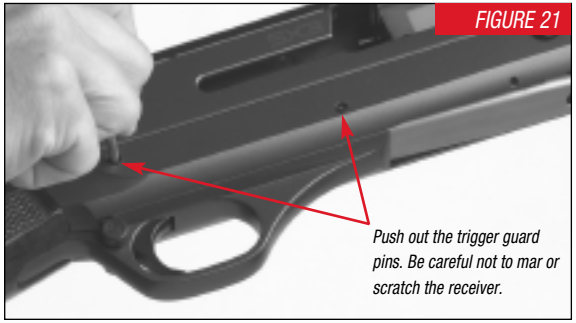
BEFORE ANY ASSEMBLY OR DISASSEMBLY PROCEDURES, COMPLETELY UNLOAD YOUR SUPER X3 SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS. PLACE THE SAFETY IN THE "ON SAFE" POSITION. ALWAYS WEAR EYE PROTECTION WHEN PERFORMING ANY MAINTENANCE OR DISASSEMBLY.

Removal of the Trigger Group —

Removing the trigger group is another necessary procedure in performing thorough maintenance of your shotgun. It is easy to do and removing it allows you to perform cleaning and maintenance whenever and wherever required.

Full disassembly involves removal of the bolt assembly and the trigger group. Any disassembly beyond this should only be performed by a qualified gunsmith.With the trigger group and bolt assembly removed, it is easy to wipe out any accumulated debris or moisture in the receiver.

1. Make sure the firearm is completely unloaded. Place the safety in the "on safe" position and leave it there during disassembly and cleaning. This assures that the hammer does not inadvertently fall forward during cleaning.
2. Under most circumstances, first remove the barrel and gas system components as explained under "Initial Assembly/Takedown" on page 10. It is acceptable for the trigger group to be removed without removing the



barrel, although it makes sense to remove the barrel if you are cleaning your firearm.

3. After removing the barrel and forearm, it is good practice to immediately screw the magazine cap back onto the magazine to secure the magazine spring retainer.
4. ***IMPORTANT: THE BOLT MUST BE SLOWLY MOVED FROM THE OPEN TO THE FORWARD, CLOSED POSITION.*** You must hold the operating handle with one hand while depressing the carrier release button with the other. Use extreme caution. If you allow the bolt assembly to slam closed with the barrel removed you can damage the receiver and affect the function of your firearm.
5. Place your firearm with the trigger guard facing up, on a suitable surface that will protect the receiver finish and stock.
6. With the firearm inverted, (trigger guard up) use a drive punch or similar object to push inward on the trigger group pins, using caution not to scratch the receiver (Figure 21). In the field, the end of the bolt slide link can be used to start the two pins out (of course you will have to remove the bolt assembly as described below before doing this). Trigger group pins may be removed from either side of the receiver. Push the trigger group pins clear through to the other side of the receiver and pull them the rest of the way out using your fingers (Figure 22).
7. Grasp the trigger group and pull it up and out of the receiver (Figure 23).

8. Perform any cleaning of the parts and receiver cavity as necessary.

For cleaning purposes no further disassembly is necessary or recommended. Do not disassemble the trigger group. Doing so may void your warranty. For repairs that require further disassembly contact a Winchester Firearms Authorized Repair Center or a qualified gunsmith as explained under "Parts, Service, Repair and Questions" on page 37.

REINSTALLATION OF THE TRIGGER GROUP —

1. Make sure the bolt is in the forward position. If the bolt is not already forward, carefully and slowly lower it to the closed position as explained previously. Use extreme caution. If you allow the bolt assembly to slam closed with the barrel removed you can damage the receiver and affect the function of your firearm.
2. Insert the trigger group back into the receiver. The holes in the trigger group should line up with holes on each side of the receiver. (If the hammer on the trigger group has been inadvertently uncocked during cleaning, it simplifies assembly if it is recocked. Do this by simply pulling the hammer back fully until it locks rearward.)
3. Reinsert the trigger guard pins, pushing them in with your hand or gently tapping them into place with a plastic or wooden mallet, again using caution not to scratch the receiver.
4. Complete assembly by installing the gas system, barrel and forearm as explained under "Initial Assembly and Takedown" on page 10.

BOLT MAINTENANCE

The bolt can be removed for normal maintenance or if the action becomes excessively dirty or wet. This shotgun is designed to allow full disassembly of the bolt assembly in the field, without any tools. Although it is possible to remove the bolt with the trigger group in place, the correct procedure when removing the bolt is to always remove the trigger group first. Removing the bolt without

removing the trigger group could allow the bolt to spring out the front of the receiver, damaging or losing parts or causing injury to you or others.

REMOVAL OF THE BOLT ASSEMBLY —

1. Remove the barrel assembly as explained previously under "Initial Assembly and Takedown" on page 10.
2. Make sure the bolt is in the forward position. If the bolt is not already forward, carefully and slowly lower it to the closed position as explained previously. Use extreme caution. If you allow the bolt assembly to slam closed with the barrel removed you can damage the receiver and affect the function of your firearm.
3. Remove the trigger group as explained under "Trigger Group Maintenance."
4. Remove the operating handle by pulling the handle outward, to the right, away from the bolt. It is held in place with a ball-detent system that may take a little effort to pull free.
5. Slide the bolt and bolt slide forward and out of the front of the receiver (Figure 24).
6. The bolt and bolt slide can be separated for cleaning (Figure 25). Perform any cleaning of the bolt and receiver cavity as necessary.

DO NOT DISASSEMBLE THE BOLT ASSEMBLY BEYOND THIS POINT.

REINSTALLATION OF THE BOLT ASSEMBLY —

Under usual conditions, the trigger group should also have been removed at this point. Reinstallation of

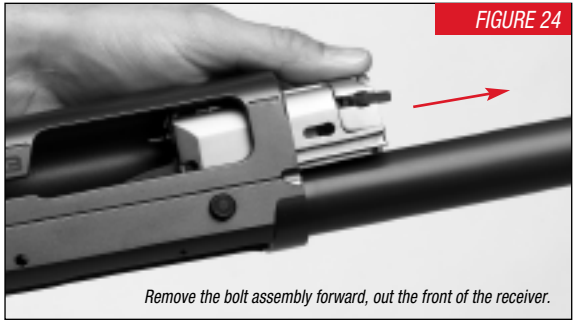
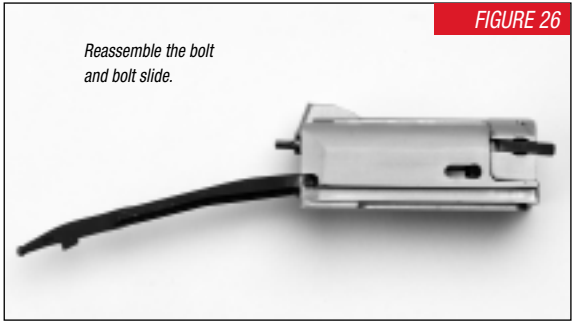


FIGURE 24

Remove the bolt assembly forward, out the front of the receiver.

FIGURE 25



the bolt assembly is easier with the trigger group removed.

1. Reassemble the bolt and bolt slide as shown (Figure 26).
2. Align the rails on the bolt slide with the matching slots in the bottom of the receiver and slide the bolt assembly into the receiver, bolt slide link end first (Figure 27). Press the carrier release button to fully insert the bolt into the receiver.
3. Guide the bolt slide link into its socket in the recoil spring follower (Figure 28). The socket can be seen at the rear of the receiver cavity. It is the cupped-shaped part that forms a recess for the bolt slide link to rest in. Become familiar with how the slide fits into the socket. It helps to keep the receiver pointing slightly upward to assure that the bolt slide link does not come out of the recoil spring follower until the barrel is reinstalled.

IMPORTANT: When your firearm is fully assembled, if it will not function properly and the action will not open, the bolt slide link is likely not properly placed in the recoil spring follower socket.

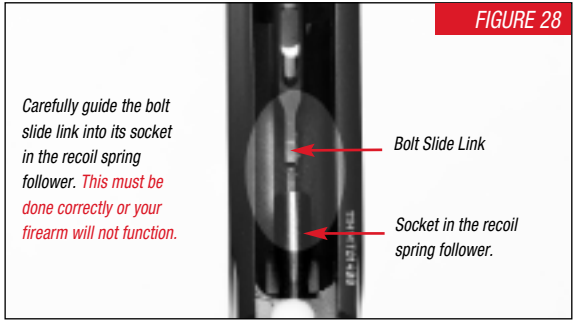


FIGURE 28
Carefully guide the bolt slide link into its socket in the recoil spring follower. This must be done correctly or your firearm will not function.
Bolt Slide Link
Socket in the recoil spring follower.

FIGURE 29

Replace the operating handle by pushing it in until it snaps into place in the spring-detent. You can feel it snap into position.

4. Replace the operating handle by pushing it in (concave side toward the front) until it engages in the ball-detent (Figure 29).
5. Again, observe that the bolt slide link and recoil spring follower are properly engaged. You can also confirm this by pulling back a bit on the operating handle. You will feel the recoil spring compress as you pull back. Do this very slowly, and make sure you control the bolt as the bolt slide link may not be properly seated into the recoil spring follower socket. If not engaged correctly, repeat step 3, making sure that the bolt slide link is installed correctly. Remember the bolt cannot lock rearward with the trigger group removed.
6. Reinstall the trigger group as explained previously (if it was removed).
7. With the trigger group installed, pull the bolt fully back until it locks in the rearward position.

TO PREVENT DAMAGING THE RECEIVER, DO NOT PRESS THE CARRIER RELEASE BUTTON UNTIL YOUR SHOTGUN IS COMPLETELY ASSEMBLED.

8. Replace the gas system, barrel and forearm as explained previously.
9. Again, pull the bolt fully to the rear until it locks open. If it will not complete its rearward movement and will not lock rearward, you have not properly installed the bolt slide link into its socket in the recoil spring follower. Refer back to step 3.
10. With all parts installed (including the barrel) your shotgun is fully assembled. It is now allowable to lock the bolt rearward then let it slam forward (closed) by pressing the carrier release button. Be sure to always keep your fingers clear of the ejection port when closing the action.

NOTE: It is possible to fit the bolt slide link into the recoil spring follower even with the trigger group installed, by holding the firearm vertically and aligning the link into the socket while looking through the operating handle slot on the right side of the receiver. This is handy if you are simply reattaching the barrel assembly after storage and the bolt has inadvertently moved forward and the bolt slide link has come out of the socket.

CLEANING AND MAINTENANCE SUGGESTIONS

Your shotgun will function better and more reliably over a longer period of time if it is properly maintained and kept clean.

BEFORE PERFORMING ANY CLEANING PROCEDURES, COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.

You should clean your shotgun after every day of shooting and more often if it becomes excessively dirty.
A minimum cleaning includes wiping down the action and oiling key parts. Most regular maintenance will also include cleaning the barrel. If you encounter a function problem be sure to give your firearm a thorough cleaning to see if it solves the problem before seeking the services of our service facility or a qualified gunsmith. To clean your firearm, adhere to the following general guidelines.

CLEANING PROCEDURES —

ALWAYS WEAR PROTECTIVE SAFETY GLASSES DURING ALL CLEANING PROCEDURES. KEEP AMMUNITION AWAY FROM THE CLEANING AREA. DO NOT TEST THE FUNCTION OF YOUR FIREARM WITH LIVE AMMUNITION. COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS. ALWAYS PLACE THE SAFETY IN THE "ON SAFE" POSITION BEFORE BEGINNING ANY CLEANING PROCEDURE.

1. Use a cleaning rod with a tip and patch suitable for the size of your shotgun's bore. Make sure the patch is large enough for a snug fit in the bore. Remove the barrel as explained previously and insert the rod and patch into the barrel at the receiver end and run it back and forth several times.
2. Inspect the chamber and bore for lead and powder fouling. A normal amount of powder residue can be expected and is not serious. It can usually be removed by repeating step one, using a patch saturated with solvent. If, or when fouling should become heavy, it can be removed with a brass bore brush. Dip or spray the brush with solvent and scrub the chamber and bore until the fouling is removed. To prevent brass bristles from breaking off, the brush should be pushed completely through the bore before being withdrawn.
3. After the fouling has been removed the bore should be wiped dry. Then pass a slightly oiled patch through the bore for preservation. A fine, light gun oil is recommended.
4. Wipe all exposed metal surfaces of the receiver, forearm and barrel with a clean rag. Finger marks should be removed because they provide a place where

moisture can accumulate. Any dried oil in the receiver area should also be removed.

5. Lightly oil your firearm at the points described under "Initial Cleaning and Oiling" on page 4. Ordinary good judgment will, of course, indicate that the metal of the firearm should receive a light film of oil any time the firearm has been exposed to weather or handling. This is very important and must be done with every firearm — even stainless steel models. Remember, the polished, finely fitted surfaces of the receiver and action mechanisms must always have a thin film of oil. Make sure that the surfaces of the bolt are especially clean and lightly oiled with a high quality gun oil.
6. ***INSPECT THE BARREL AND CHAMBER. MAKE CERTAIN THAT NO PATCHES HAVE BEEN INADVERTENTLY LEFT IN THEM. REMOVE ANY THAT REMAIN.***
7. Wipe all wood surfaces with a soft cloth.
8. When transporting only, store your shotgun in a quality protective case to prevent scratches and dents. Store in a dry place to prevent corrosion. Store away from children.

ALWAYS STORE AMMUNITION SEPARATELY. COMPLETELY UNLOAD YOUR SHOTGUN. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.

CLEANING THE ACTION AND TRIGGER GROUP —

1. When the action becomes excessively dirty, remove the trigger group and bolt assembly from the receiver as explained under "Bolt Maintenance" on page 30. Clean with a good quality light oil, a gun solvent or spray "scrub" as necessary, using an old toothbrush to loosen any caked-on grime. Wipe the receiver cavity clean. Lightly oil the cavity and wipe it dry. No further disassembly is required for cleaning.
2. Reassemble as explained previously and wipe all exposed metal surfaces with an oiled cloth, making sure to wipe clean all finger marks where moisture will accumulate.
3. The barrel and action should be inspected to assure that all cleaning patches have been removed and not inadvertently left in the barrel or action.

CLEANING THE GAS SYSTEM —

1. Remove the gas piston and piston sleeve from the magazine tube. Do no attempt to disassemble gas piston components, it is not necessary for normal maintenance and risks losing parts and damaging your firearm. Spray the magazine tube with a good quality powder solvent and wipe clean.
2. Spray the gas piston and gas bracket with a good quality powder solvent. Brush them thoroughly to remove any

deposits using an old toothbrush. Spray the inside of the gas piston and gas bracket and wipe off any carbon buildup. A green Scotch-Brite® kitchen scrub pad works best for removal of heavy carbon fouling on the magazine tube and inside the gas piston. Do not attempt to remove the spring inside of the gas piston.

NEVER USE A STEEL BRUSH ON ANY OF THE GAS SYSTEM COMPONENTS.

3. Complete the cleaning of the gas system by applying a very light film of gun oil to all parts for protection and lubrication.

CLEANING THE MAGAZINE —

It is a good idea — especially if your firearm becomes excessively dirty or very wet — to occasionally clean the magazine system. Remove the magazine spring retainer, plug, magazine spring and magazine follower, following the instructions under "Magazine Three-Shot Adapter (Plug)" on page 18 in this owner's manual. Clean the inside of the magazine tube using a rod and patch just as you would clean a barrel. Carefully wipe off the magazine spring and plug. Very lightly oil each component. Reinstall all parts as explained earlier.

CLEANING THE INVECTOR-PLUS™ CHOKE SYSTEM —

1. Do not use a brass brush to clean your barrel unless a choke tube is installed in the barrel. Bristles could break off and lodge in the threads, making installation and removal of choke tubes difficult.
2. Regularly remove your firearm's choke tube in order to clean and oil the threads inside the barrel, as well as on the choke tube itself. This will protect the threads from being damaged and also prevent a dirt build-up that would cause the choke tube to become difficult to remove from the barrel. Clean the threads with solvent and a small, soft brush like a toothbrush. Wipe completely clean and leave a thin film of clean oil on the threads — both on the tube and in the barrel. The threads of the choke tube and the internal threads of the barrel should be cleaned after each use and before the installation of a tube.
3. Be careful when removing/installing a tube. Use the specially designed wrench. Damage can result to both the choke tube and barrel when attempting to remove sticky choke tubes.
4. Never fire your shotgun or run cleaning tools through the barrel of any choke-tubed firearm without having the choke tube installed.

NEVER ATTEMPT TO DISASSEMBLE YOUR SHOTGUN FURTHER THAN EXPLAINED IN THIS OWNER'S MANUAL.

This is a specialized, finely fitted mechanism. You may permanently mar it by attempting to disassemble the inner mechanism assemblies. If further disassembly for

service or cleaning is required, take your firearm to a Winchester Firearms recommended Authorized Repair Center or a qualified gunsmith as explained under "Parts, Service, Repair and Questions" on page 37.

OTHER CLEANING SUGGESTIONS —

- Never pour large quantities of oil into the receiver or other parts. It can drain down to the wood and soften it, causing permanent damage and loosening of the stock.
- After extended periods of heavy use, your shotgun should be taken to a qualified gunsmith to have the action disassembled for professional cleaning and lubrication.

CLEANING PARTS WITH SPECIAL FINISHES —

Be especially careful when cleaning firearms with camouflage, Dura-Touch® Armor Coating and other special finishes. Always prevent these surfaces from coming in contact with cleaning solvents, barrel scrubbers and other strong chemicals. It is preferable to clean these surfaces with a light gun oil containing no solvents or with a damp cloth and mild dish soap (be sure to keep water out of the action). When cleaning your firearm's bore and action, protect the external finishes from any contact with chemicals used. Also, avoid any contact between external finishes and other strong chemicals like those found in DEET-containing insect repellents, sunscreens, etc. Damage to camouflage, Dura-Touch and other finishes caused by chemicals is irreversible and unrepairable.

PARTS, SERVICE, REPAIR AND QUESTIONS

If your Winchester rifle or shotgun should ever need service or repair, it is often best to utilize one of our Authorized Repair Centers. In some cases it is appropriate to use the Winchester Rifles and Shotguns Service Center in Arnold, Missouri. A list of Authorized Repair Centers was included with your new firearm. If you need a new listing, contact us. We can help you determine the best place to service your firearm.

In order to avoid delays, it is important to never send your gun directly to our facility without direct authorization from one of our service specialists. This avoids possible delays in obtaining service. Contact us at (800) 322-4626 for details on how to receive service before sending your gun.

Parts listings, Authorized Repair Center lists, service procedures, service/repair form and general product information are also found on the Web at: **www.winchesterguns.com.**

When returning your firearm for servicing, you must do the following:

1. Be sure it is completely unloaded.
2. Remove the scope or other optics.
3. Package it securely in a cardboard container.
4. When sending your firearm, enclose the service/repair form available at www.winchesterguns.com or a letter that clearly describes the trouble experienced, the ammunition used and the repairs desired. Also include your name and a daytime phone number where you can be reached.
5. If convenient, send a copy of the service/repair form or letter to us separately.
6. Never return ammunition with your firearm. It is against postal and most commerce regulations.

PARTS, SERVICE, REPAIR STATUS AND TECHNICAL QUESTIONS —

Winchester Rifles and Shotguns
Parts and Service
BACO, Inc.
3005 Arnold Tenbrook Road
Arnold, MO 63010-9406
(800) 322-4626

GENERAL PRODUCT AND HISTORICAL QUESTIONS —

Winchester Rifles and Shotguns
Customer Service
BACO, Inc.
275 Winchester Avenue
Morgan, UT 84050-9333
(800) 945-5237

CAUTION: PARTS ARE MADE FOR WINCHESTER BRAND FIREARMS MANUFACTURED BY OR FOR WINCHESTER RIFLES AND SHOTGUNS, AND SHOULD NOT BE USED IN OTHER GUNS, EVEN THOUGH MODELS MAY BE SIMILAR. IMPROPERLY FITTED PARTS MAY BE DANGEROUS.

WEBSITE INFORMATION

An information resource for Winchester Rifles and Shotguns is found on the World Wide Web.

- List of Authorized Repair Centers.
- Customer Service information.
- Firearm Service/Repair Form.
- Answers to many technical and historical questions.
- Links to helpful sites.

Go to: www.winchesterguns.com

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275 Winchester Avenue
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